

Date: Tuesday, 7/17/2007 2:00:28 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET ASSEMBLY		
Job Number	: 33589					
Estimate Number	: 11030					
P.O. Number	: N/A			Part Number	: D2803042	
This Issue	: 7/17/2007 S.O. No.: N/A			Drawing Number	: D2803 REV B	
Prsh Rev.	: NC			Project Number	: N/A	
First Issue	: N/A			Drawing Revision	: B	
Previous Run	: 29392			Material	: N/A	
Written By	:			Due Date	: 7/31/2007	
Checked & Approved By	:			Qty:	10 Um: Each	
Comment	: Est F 05.03.30 MS21043-3 was MS21042L3 KJ/JLM					

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D28032	STA 84 Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

STA 84 BRACKET

Pick:

Qty	Part Number	Description	Batch
1	D2803-2	Bracket	B33589 X 10



2.0	D28052	Stop
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

STOP

Pick:

Qty	Part Number	Description	Batch
1	D2805-2	Stop	B33600 / B34033 (X 10)



3.0	D2809	Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Bushing

Pick:

Qty	Part Number	Description	Batch
1	D2809	Bushing	B34035



4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Press D2805-2 into arm as per Dwg D2803

MLO7/08/07 X10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/08/29	5	Split w/o green	SB	07/08/29	7		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Job Number: 33589

Part Number: D2803042

Job Number:



Seq. #:	Machine Or Operation:	Description :												
1.0	QC5	INSPECT WORK TO CURRENT STEP												
3.0	POWDER COATING	<p>Comment: INSPECT WORK TO CURRENT STEP</p> <p>7 PCS - M1023/G1 POWDER COATING green S/N: 7X green</p>												
3.0	POWDER COATING	<p>Comment: POWDER COATING</p> <p>3 PCS - white M105068 white S/N: 3X white. 7E</p>												
7.0	QC3	<p>Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION</p> <p>INSPECT POWDER COAT/CHEMICAL CONVERSION</p> <p>mf 07-08-29</p>												
8.0	SMALL FAB 1	<p>Comment: SMALL &amp; MEDIUM FAB RESOURCE 1</p> <p>Press D2809 into arm as per Dwg D2803</p> <p>mf 07-08-29</p>												
9.0	AN3C16A	<p>Bolt</p> <p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)</p> <p>Bolt</p> <p>Pick:</p> <table> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>AN3C16A</td> <td>Bolt</td> <td>m102552</td> </tr> </tbody> </table> <p>mf 07-08-29</p>	Qty	Part Number	Description	Batch	2	AN3C16A	Bolt	m102552				
Qty	Part Number	Description	Batch											
2	AN3C16A	Bolt	m102552											
10.0	MS210433	<p>Nut</p> <p>Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)</p> <p>Nut</p> <p>Pick:</p> <table> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>MS21043-3</td> <td>Nut</td> <td>m105211</td> </tr> </tbody> </table> <p>mf 07-08-29</p>	Qty	Part Number	Description	Batch	2	MS21043-3	Nut	m105211				
Qty	Part Number	Description	Batch											
2	MS21043-3	Nut	m105211											
11.0	NAS1515H3	<p>Washer</p> <p>Comment: Qty.: 4.0000 Each(s)/Unit Total : 40.0000 Each(s)</p> <p>Washer</p> <p>Pick:</p> <table> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>4</td> <td>NAS1515H3</td> <td>Washer</td> <td>m105164</td> </tr> <tr> <td>A/R</td> <td>LPS-3</td> <td>Corrosion Spray</td> <td>m104929</td> </tr> </tbody> </table> <p>Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2803</p> <p>mf 07-08-29</p>	Qty	Part Number	Description	Batch	4	NAS1515H3	Washer	m105164	A/R	LPS-3	Corrosion Spray	m104929
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4	NAS1515H3	Washer	m105164											
A/R	LPS-3	Corrosion Spray	m104929											

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Seq. #:

Machine Or Operation:

Description :

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D2803.

mf

07-08-29

7

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/08/09

77

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

mf 07-08-30

7

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

En 07/08/31

77  
07/08/31

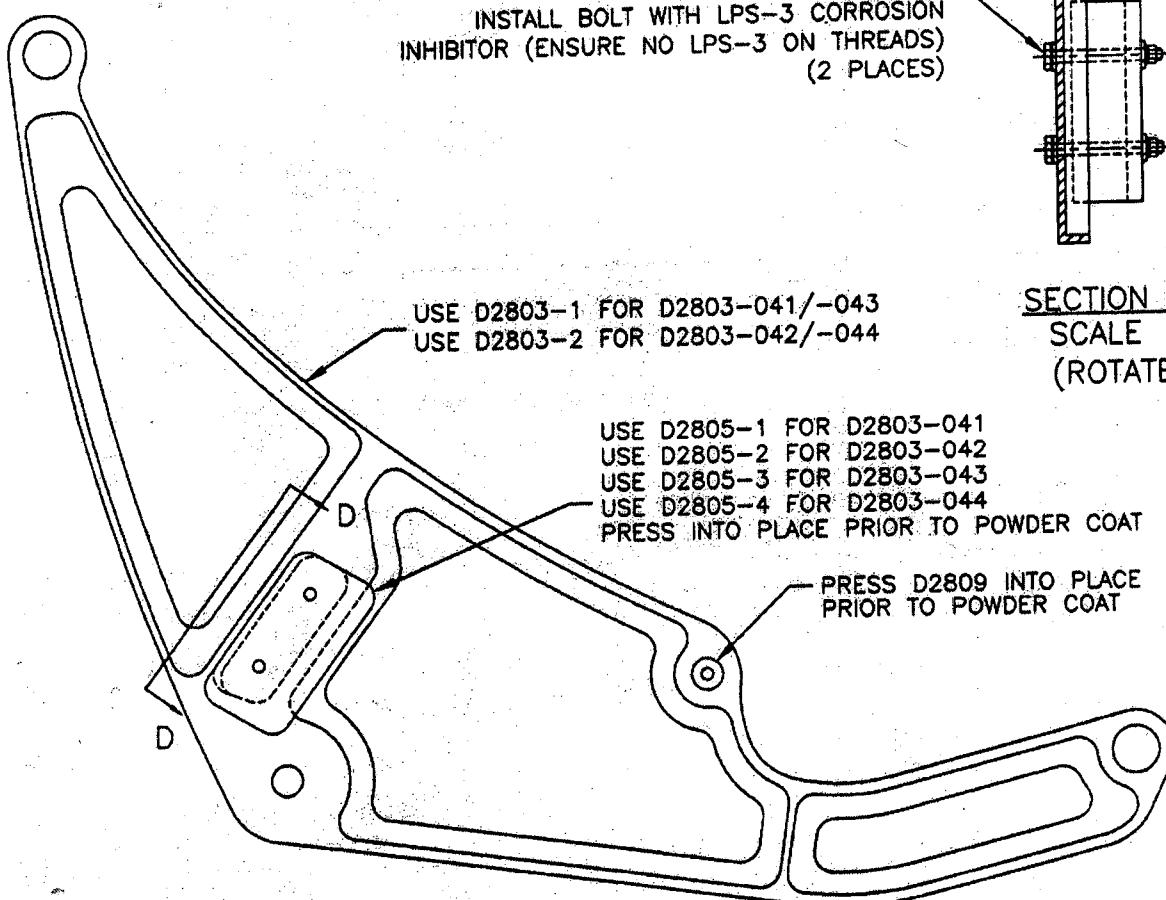
Job Completion



U 07/08/31

**DART**

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2803	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 84 BRACKET	SCALE 1:3



SECTION D-D  
SCALE 1:3  
(ROTATED)

SHOP COPY  
RETURN TO  
ENGINEERING  
**RELEASED** *[Signature]* CONTROLLED C  
05-03-11 SUBJECT TO AMENDM  
WITHOUT NOTICE  
WORK ORDER  
NO. 3358

D2803-041/-043 BRACKET ASS'Y (SHOWN)  
D2803-042/-044 BRACKET ASS'Y (OPPOSITE)

6 FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6)  
OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3